



NOTES CONTINUED FROM SHEET 1 ZONE 60

F) REPEAT STEPS (C) THRU (E) UNTIL THE REQUIRED CLEARANCE IS OBTAINED.

G) **15/18** REMOVE QUILL ASSY FROM THE TRANSMISSION (REF. NOTE 8D/E) AND INSTALL M83248/1-248 O-RING, MIL-S-8802 SEALANT AND MASTINOX 685K CORROSION PREVENTIVE COMPOUND ON THE TRANSMISSION AND/OR QUILL ASSY PER DRAWING INSTRUCTIONS.

H) REINSERT THE QUILL ASSY INTO THE TRANSMISSION AND COMPLETE ALL OTHER QUILL INSTALLATION OPERATIONS.  
(SEE SHEET 2 FOR -01 & -39 INSTALLATION)

I) INSTALL BRACKET P/N 205-040-114-001 AS PER INSTALLATION VIEW A-A SHEET 2A ZONE 2B.

J) FOLLOWING INSTALLATION OF THE 212-040-703 (-39) & 412-040-703 (-01) QUILL ASSY. REF., CONFIRM THE EXISTENCE OF BACKLASH BETWEEN THE 212-040-702 (-39) & 412-030-310 (-01) PINION AND THE 204-040-701 (-39) & 412-040-701 (-01) GEAR WITHIN THE TRANSMISSION BY ROTATING (ROCKING) THE PIN BACK AND FORTH BY MEANS OF ITS SPLINED OUTPUT SHAFT IN THE LOWER ACCESSORY DRIVE PAD. THE AMOUNT OF BACKLASH NEED NOT BE MEASURED.

**10** INSTALL -21 TROUGH REF. AS FOLLOWS:

- CUT AND REMOVE EXISTING TROUGH PER DIMENSIONS SHOWN.
- PRO-SEAL AND TACK -03, -05, AND -07 NUTPLATE STRIP ASSY. ONTO EXISTING TROUGH EDGE AS SHOWN.
- MATCH DRILL -21 TROUGH TO (INSTALLED) -03, -05, AND -07 ASSY. 31 PLACES.
- INSTALL -37 ASSY USING MS27039-1-08 SCREWS & AN960PD10L WASHER (5 PL) AND VIEW C-C WHEN APPLICABLE.
- ATTACH -21 TROUGH TO ACFT USING AW5251OR8 SCREW 31 PL. REF.
- APPLY AB 890 PROSEAL TO PLATENUTS ON -03, -05, & -07 ASSY AND EDGES OF MODIFICATION TO PREVENT MOISTURE LEAKAGE.

**11** REF. WIRE DIAGRAM 400 AMP GENTERATOR, B23-12000. (PREMIER)

**12** SAFETY WIRE PER MS33540 AS APPLICABLE.

**13** BEFORE RIVETING ASSY, MUST BE PERFORMED TO GENERATOR! REINSTALL PROTECTIVE BACKING BEFORE INSTALLATION. CAUTION:: NO BURRS / SCREEN MUST NOT INTERFERE WITH INTERNALS OF GENERATOR!!

**14** **15** PRIOR TO INSTALLATION OF SET SCREW: PREPARE SET SCREW AND THREADED HOLE IN CASE. APPLY A THIN COAT OF MIL-S-8802 SEALANT TO THE THREADED PORTION OF SET SCREW ONLY. NO SEALANT SHALL BE PRESENT ON POINT OF THE SET SCREW OR IN THREADED HOLE PRIOR TO INSTALLATION OF THE SET SCREW. AFTER INSTALLATION OF SET SCREW, INSURE THAT NO SEALANT IS PRESENT ON ADJACENT SURFACES OR IS PROTRUDING FROM THREADED HOLE.

**15** DO NOT EXPOSE SEALANT-COATED PARTS TO OIL FOR 24 HOURS AFTER SEALANT HAS BEEN APPLIED IF CURED AT ROOM TEMPERATURE. CURING MAY BE EXPEDITED BY HEATING AT 120 DEGREES F +/- 10 DEGREES F FOR (8) HOURS. AFTER WHICH TIME PARTS MAY BE EXPOSED TO OIL.

**16** INSTALLATION OF MS51964-97 SET SCREW ONLY APPLIES TO 212 SHIP SERIAL NUMBERS 30680 THRU 30939.

**17** **18** APPLY A THIN EVEN FILM OF MASTINOX 685K CORROSION PREVENTIVE COMPOUND TO INDICATED AREAS OF THE TRANSMISSION QUILL PORT AND THE QUILL ASSEMBLY IMMEDIATELY PRIOR TO INSTALLATION OF THE QUILL. THIN COMPOUND AS REQUIRED WITH MEK TO OBTAIN A BRUSHABLE CONSISTENCY.

**18** BEFORE APPLYING FRESH CORROSION PREVENTIVE COMPOUND IN ACCORDANCE WITH NOTE 17. THE BORE AND FACE OF THE TRANSMISSION ACCESSORY QUILL PORT MUST BE COMPLETELY CLEANED OF ANY SEALANT, PAINT, AND CORROSION PREVENTIVE COMPOUND RESIDUE.

**19** **15** AFTER INSTALLATION OF QUILL ASSY., APPLY A SMALL BEAD OF MIL-S-8802 SEALANT AT THE TRANSMISSION TO QUIL INTERFACE

- 20** **15** AFTER ASSEMBLING QUILL ASSY. INTO TRANSMISSION ASSY., COAT SURFACE OF PLUG WITH MIL-S-8802 SEALANT. INSTALL PLUG AND APPLY A BEAD OF MIL-S-8802 SEALANT AROUND PROTRUDING O.D. OF PLUG.
- 21** CAUTION: THIS KIT MUST NOT BE INSTALLED IN 212-040-001 OR 412-040-002 TRANSMISSION ASSEMBLIES.
- 22** CAUTION: THE 412-040-703 QUILL ASSY. IS A LOOK-ALIKE PART. ENSURE THAT THE 412-040-310 GEAR HAS FOUR HOLES IN ITS WEB, AS SHOWN IN VIEW D-D SHEET 2A.
- 23** AFTER COMPLETION OF QUILL INSTALLATION REPLACE DECAL AS SHOWN IN VIEW E SHEET 2A ZONE 5A.
- 24** THE -41 SPLICE REF. IS FOR PREMIER HOIST INSTALLATION ONLY, AND IS NOT INSTALLED WITH STANDARD GENERATOR/PUMP QUILL INSTALLATION.

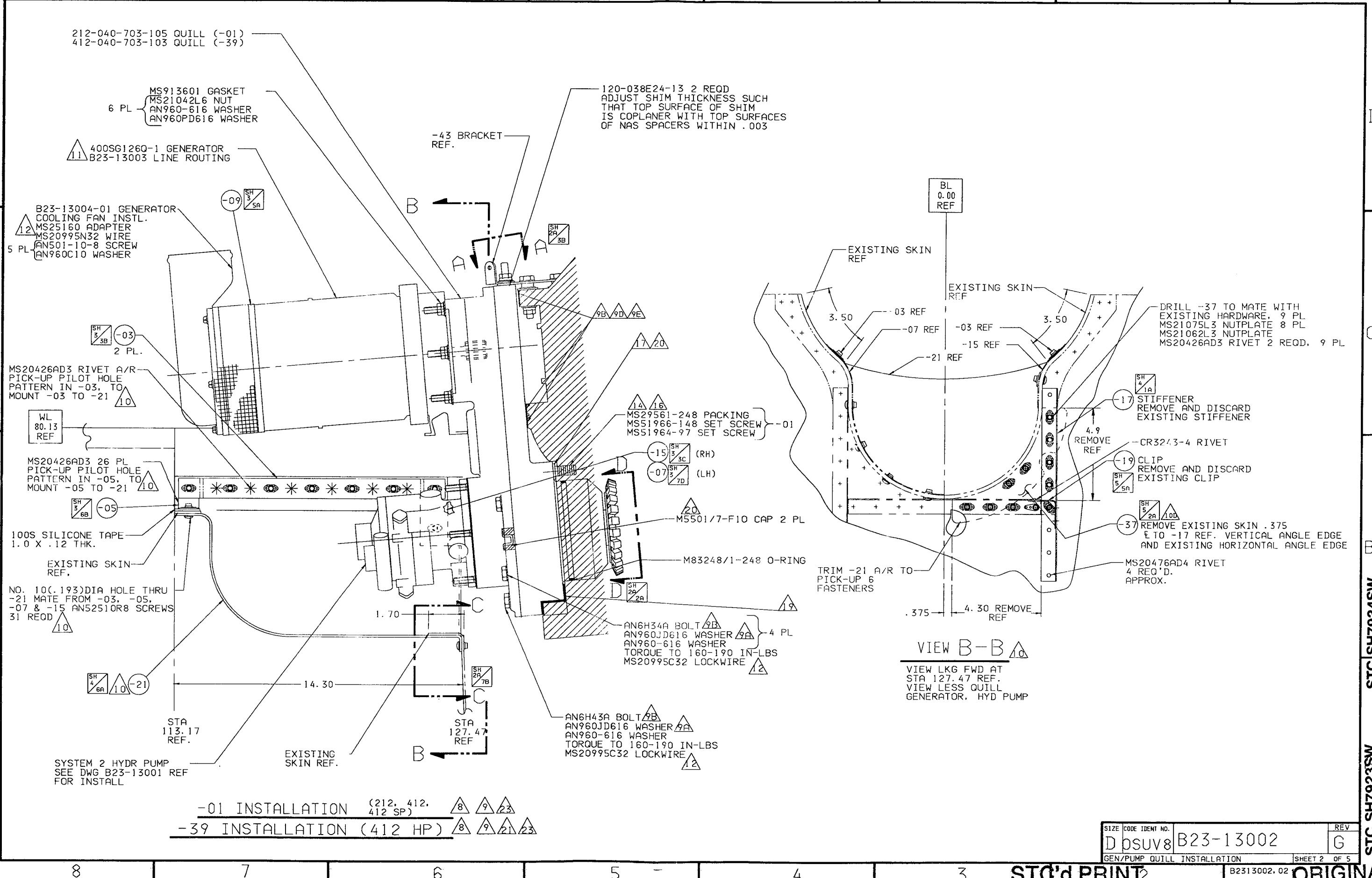
REF				REF	B23-13004-01	GENERATOR COOLING FAN INSTL.	Premier				
REF				REF	B23-13003	GENERATOR LINE ROUTING INSTALLATION	Premier				
REF				REF	B23-13002-75	STRAP	Premier				
REF				REF	B23-13001	MOD SYS 2 HYD PUMP INSTL	Premier				
REF				REF	B23-12000	WIRE DIAGRAM 400 AMP GEN.	Premier				
A/R				A/R	965073/3623-03	LABLE TAPE	GENERAL BINDING				
1					412-040-703-103	QUILL	BHT				
REF				REF	400SG126Q-1	GENERATOR	AIRCRAFT PARTS CORP				
1				1	212-075-033-103	DECAL	BHT				
1				1	212-040-199-001	WASHER	BHT				
				1	212-040-703-105	QUILL	BHT				
1				1	205-040-114-001	BRACE	BHT				
A/R				A/R	120-038E24-13	SHIM	BHT				
A/R				A/R	100S	SILICONE TAPE 1.0 x .12 THK	CHR Industries				
REF				REF	T101338	JACKSCREW SET	BHT				
A/R				A/R	MIL-S-8802	SEALENT	BHT				
A/R				A/R	MASTINOX 685K	CORROSION PREVENTIVE COMPOUND	AMERICAN EUROCOPTER				
1				1	CR3243-4	RIVET	CHERRY				
	A/R	A/R	A/R	AB 890		PORSEAL	HYSOL				
4				4	NAS43HT6-25	SPACER					
1				1	M83248/1-248	O-RING					
2				2	M5501/7-F10	CAP					
1				1	MS913601	GASKET					
				1	MS51966-148	SET SCREW					
				1	MS51964-97	SET SCREW	△6				
				1	MS29561-248	PACKING					
5				5	MS27039-1-08	SCREW					
1				1	MS25160	ADAPTER					
8	2	1	4	6	7	8	MS2107SL3	NUTPLATE			
		1					MS21069L3	NUTPLATE			
1							MS21062L3	NUTPLATE			
12							12	MS21042L6	NUT		
A/R				A/R	MS20995N32	WIRE					
A/R				A/R	MS20995C32	WIRE					
A/R	A/R	A/R	A/R	A/R	A/R	MS20426AD3	RIVET				
A/R					A/R	MS20426AD4	RIVET				
QTY PER	QTY PER	PART NO.	DESCRIPTION	SPECIFICATION	CODE IDENT NO.	ITEM NO.					
-39	-37	-15	-09	-07	-05	-03	-01	PARTS LIST			

NOTES CONTINUED ZONE 5D

SIZE	CODE IDENT NO.	REV.
D	OSUV8 B23-13002	G
GEN/PUMP OIL LIT. INSTALLATION		SHEET 1A OF 5

8 7 6 5 4 3 2 1

212-040-703-105 QUILL (-01)  
412-040-703-103 QUILL (-39)

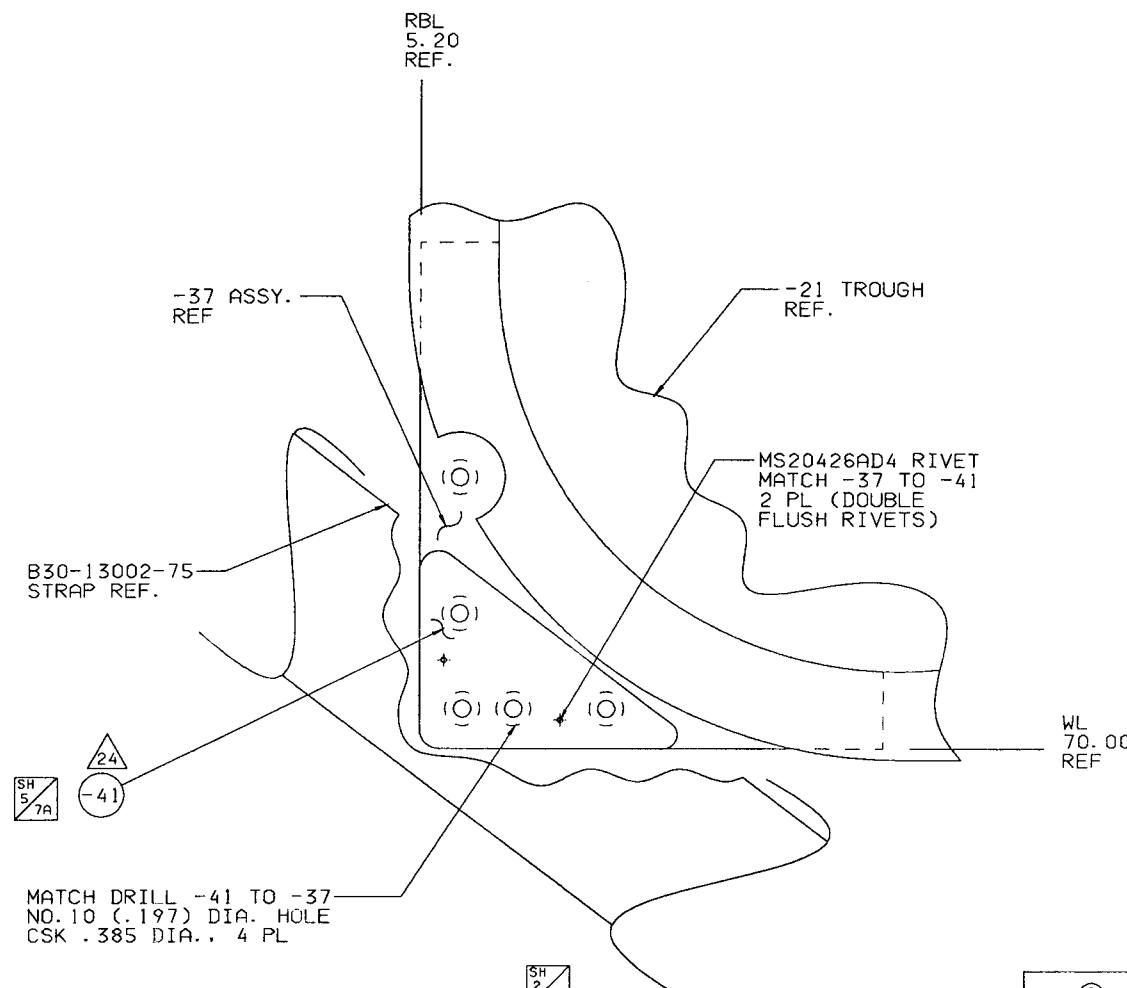


SHEET 2 OF 5

SIZE CODE IDENT NO.  
D DSUV8 B23-13002  
GEN/PUMP QUILL INSTALLATION

8 7 6 5 4 3 STC'd PRINT B2313002, 02 ORIGINAL

8 7 6 5 4 3 2 1

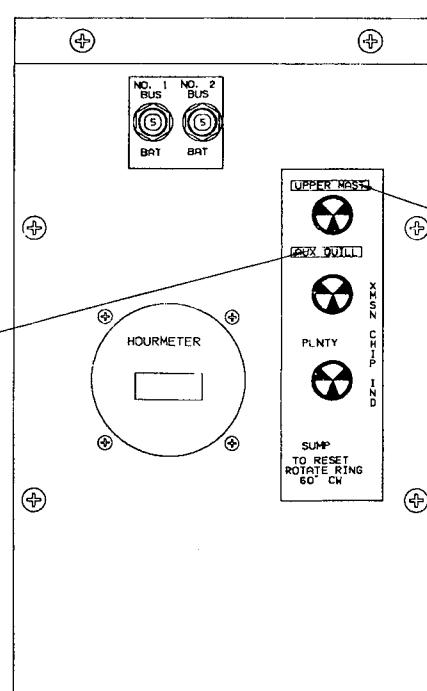


VIEW C-C

VIEW LKG AFT  
@ STA 127.47 REF  
(ALT VIEW FOR  
PREMIER HOIST INSTL)

REMOVE EXISTING MAST LABEL TAPE  
AND REPLACE WITH LABEL SHOWN  
CROIX TYPE  
FONT: HELVETICA  
MEDIUM 12 POINT  
WHITE ON CLEAR

WL  
22.00  
REF.



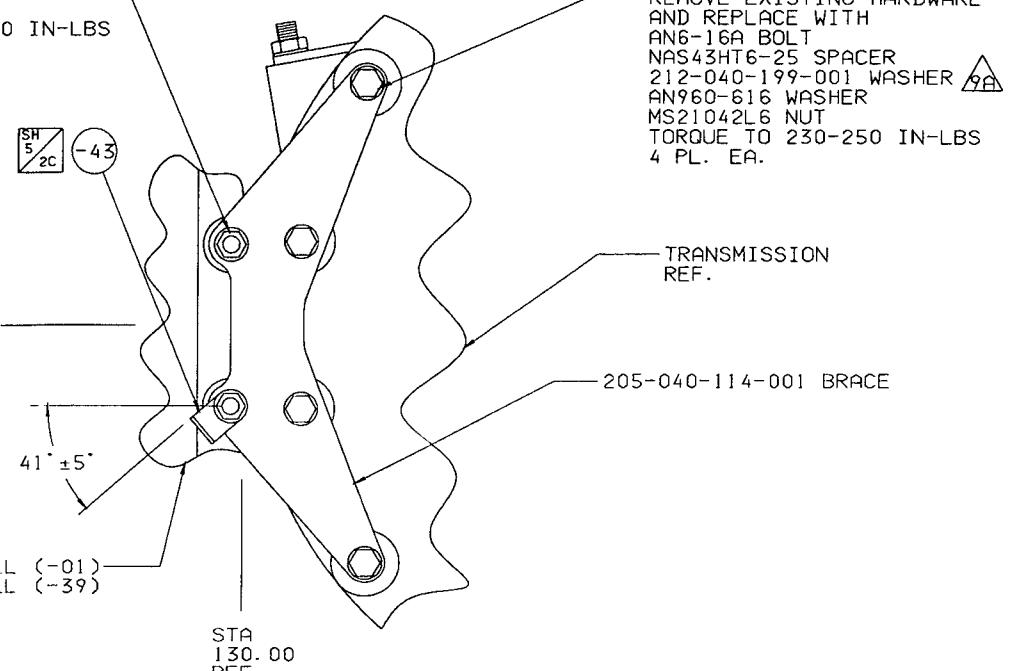
VIEW E

VIEW LKG INBD  
@ RBL 8.00 REF

STA  
37.00  
REF.

FWD

MS21042L6 NUT  
AN960-616 WASHER  
TORQUE TO 160-190 IN-LBS  
2 PL. EA.

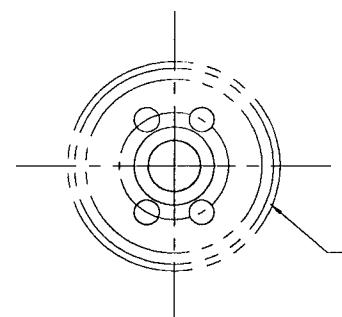


VIEW A-A

VIEW LKG DOWN  
@ WL 127.47 REF

SH 2/5c

REMOVE EXISTING [UPPER] LABEL TAPE  
AND REPLACE WITH LABEL SHOWN  
CROIX TYPE  
FONT: HELVETICA  
MEDIUM 12 POINT  
WHITE ON CLEAR



VIEW D-D

VIEW LKG FWD  
@ WL 132.00 REF.

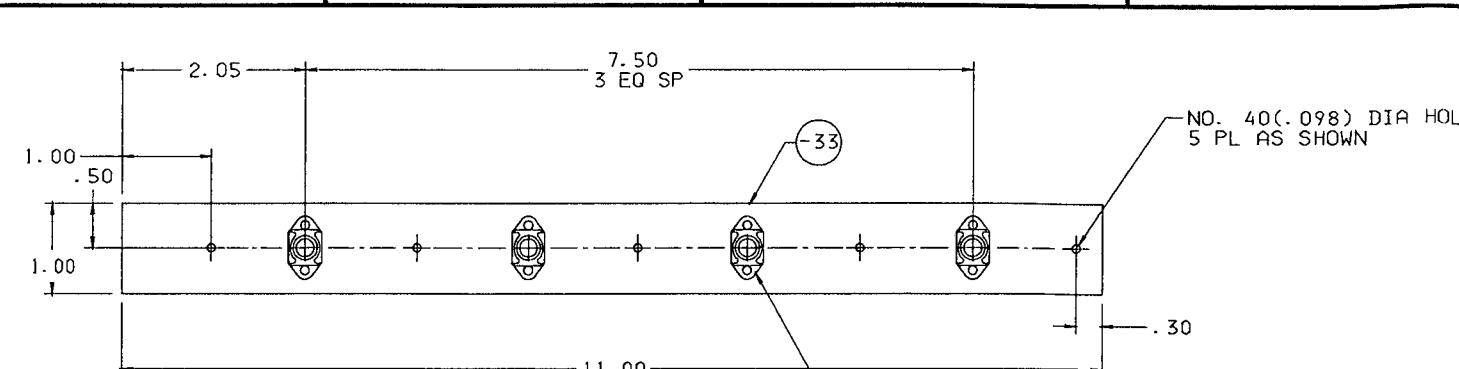
SIZE CODE IDENT NO.  
D OSUV8 B23-13002

REV  
G

GEN/PUMP QUILL INSTALLATION

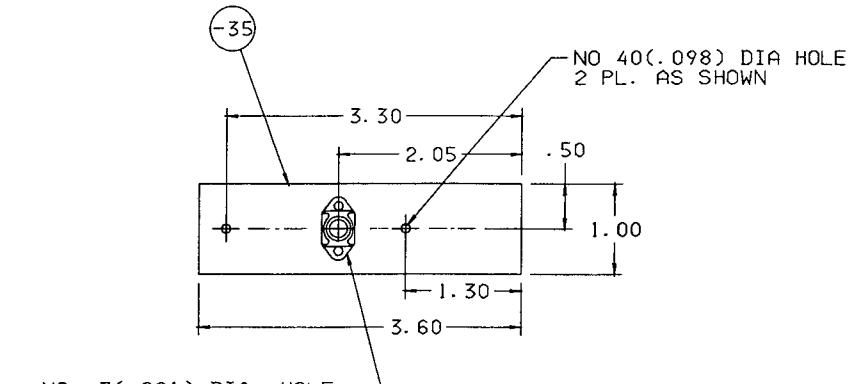
SHEET 2A OF 5

8 7 6 5 4 3 2 1



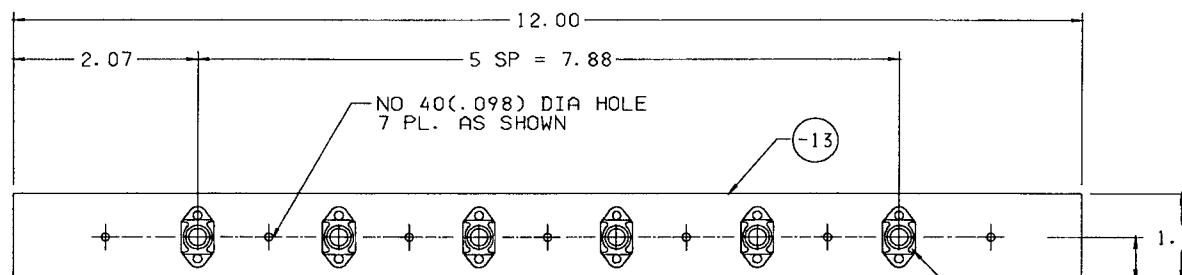
-07 ASSY

MATL: .050 THK ALUM 2024-T3  
QQ-A-250/4



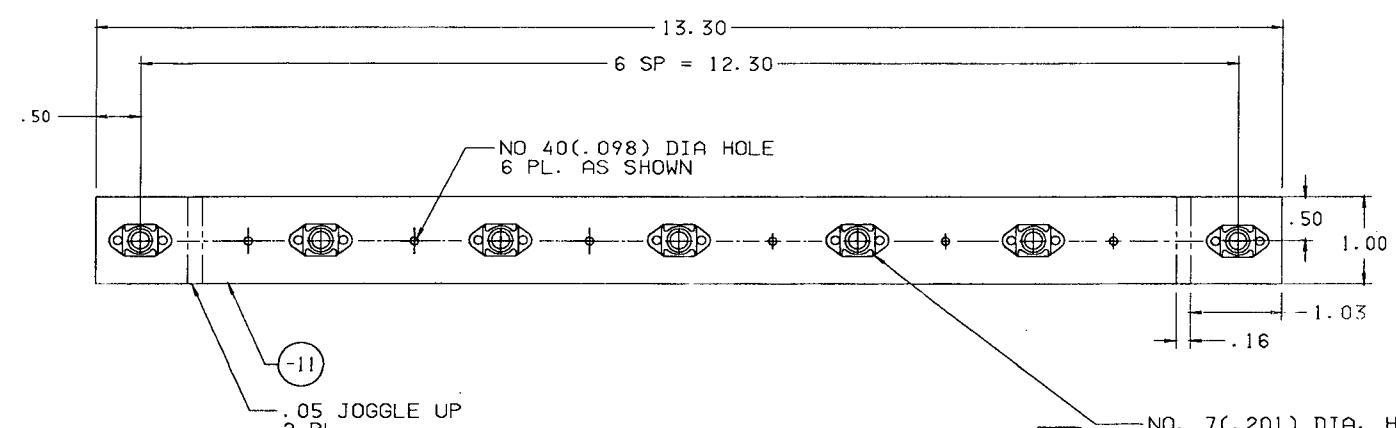
-15 ASSY

MATL: .050 THK ALUM 2024-T3  
QQ-A-250/4



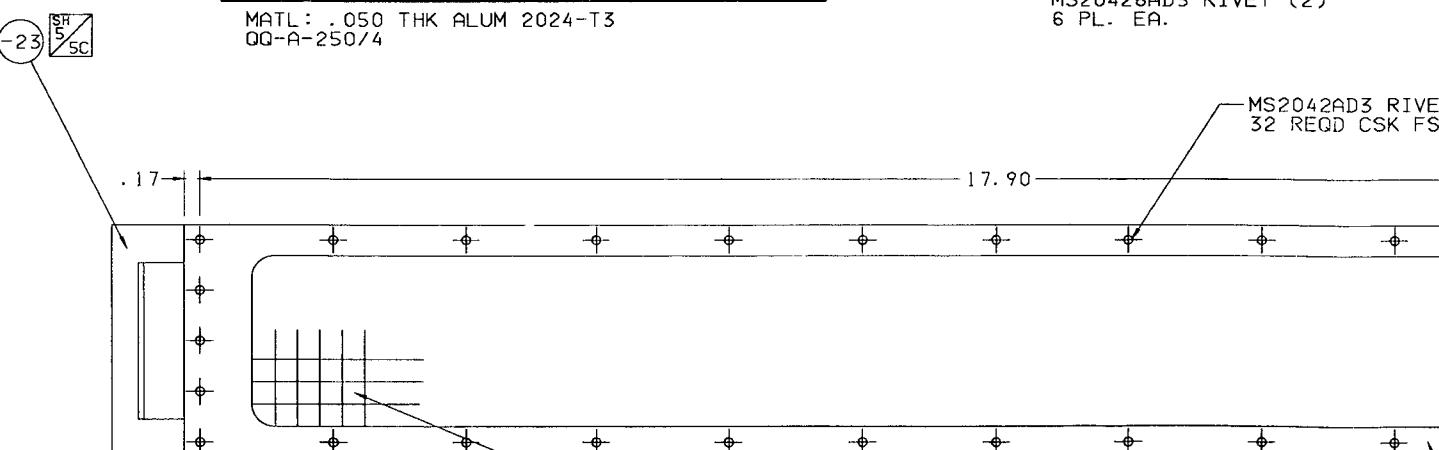
-05 NUTPLATE STRIP ASSY

MATL: .050 THK ALUM 2024-T3  
QQ-A-250/4



-03 NUTPLATE STRIP ASSY

MATL: .050 THK ALUM 2024-T3  
QQ-A-250/4



-09 ASSY

2 REQD

.25 WIRE CLOTH  
SAME DIMINION AS -25  
(SEE SHEET 4 ZONE 5C)

25 REF

25 REF

23 REF

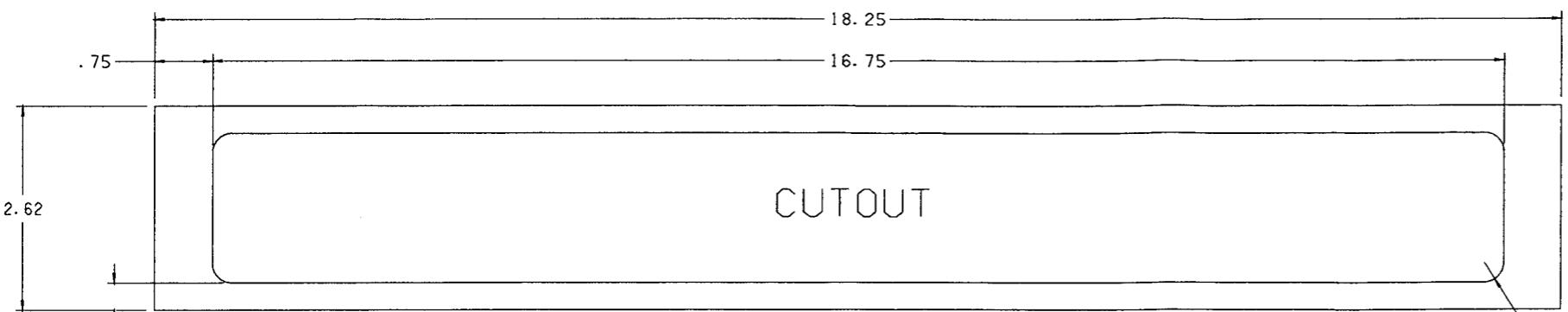
SIZE CODE IDENT NO.  
D bSUV8 B23-13002  
REV G  
GEN/PUMP QUILL INSTALLATION  
SHEET 3 OF 5

STC'd PRINT B2313002, 03 ORIGINAL

STC SH7934SW

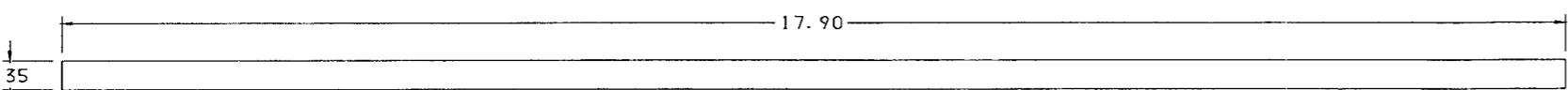
STC SH7923SW

8 7 6 5 4 3 2 1



-25 DOUBLER

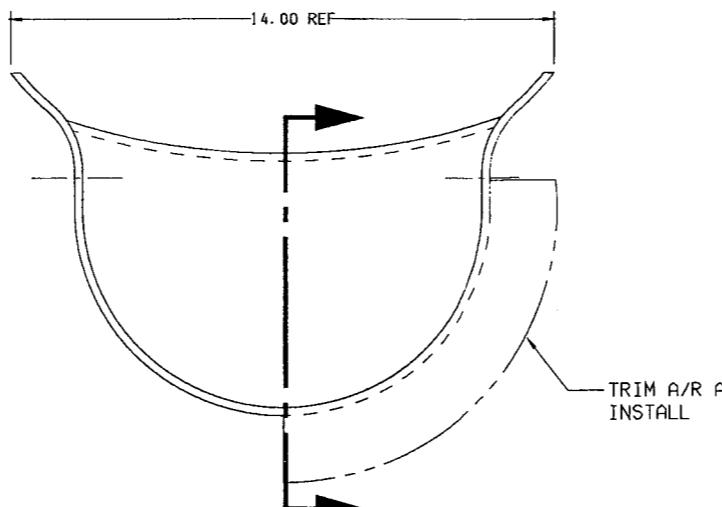
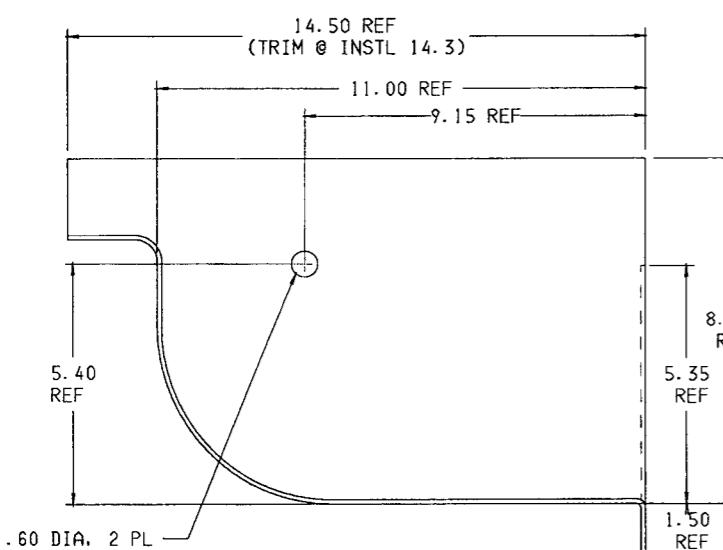
MAT'L.: .050 THK 2024-T3  
QQ-A-250/4



-27 SPACER

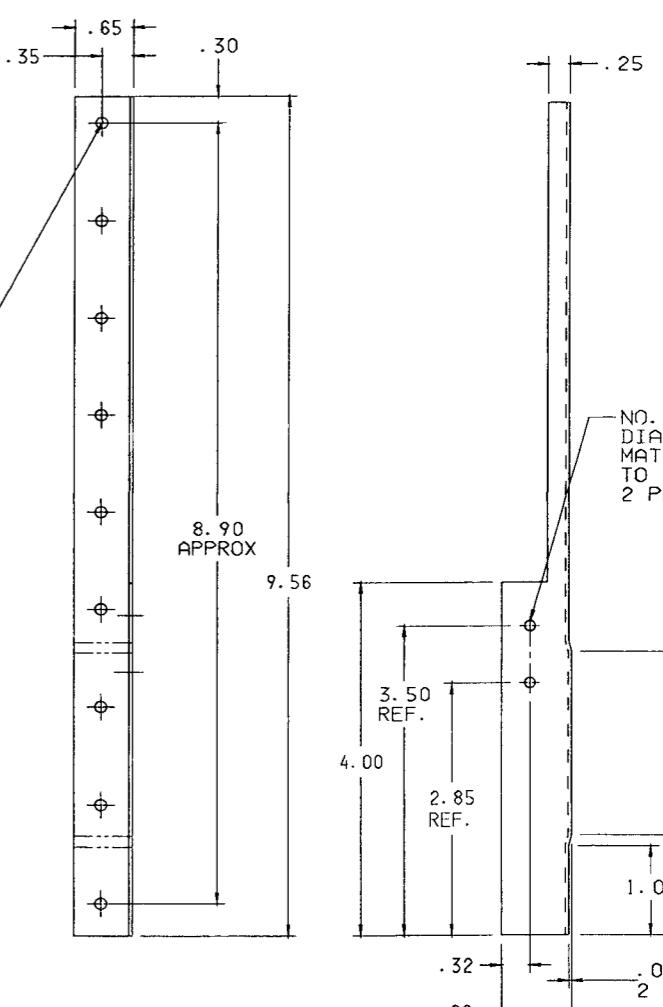
MAT'L.: .050 THK 2024-T3  
QQ-A-250/4

NO. 30 (.128) DIA HOLE  
MATCH DRILL TO EXISTING  
ACFT RIVET PATTERN



-21 TROUGH

MAT'L: 3 PLY-BIDIRECTIONAL FIBERGLASS



-17 STIFFENER

MAT'L.: .040 THK 2024-T3  
QQ-A-250/4

SIZE	CODE IDENT NO.	REV
D OSUV8	B23-13002	G

GEN/PUMP QUILL INSTALLATION SHEET 4 OF 5

STC'd PRINT B2313002.04 ORIGINAL

8 7 6 5 4 3 2 1

STC SH7923SW STC SH7934SW

8 7 6 5 4 3 2 1

D

D

C

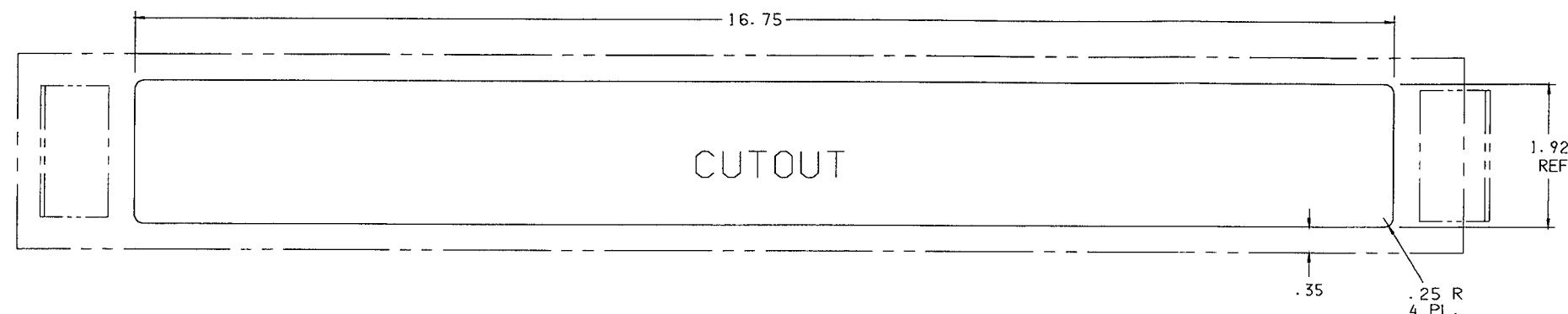
C

B

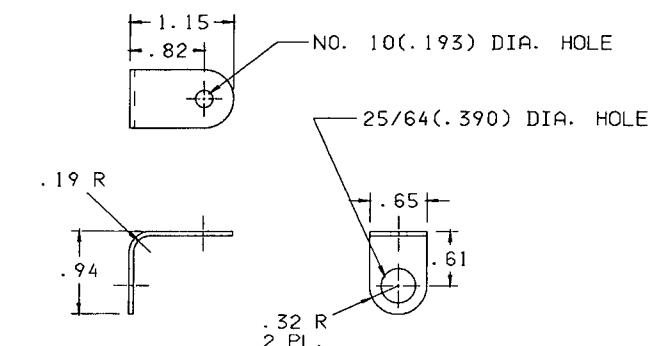
B

A

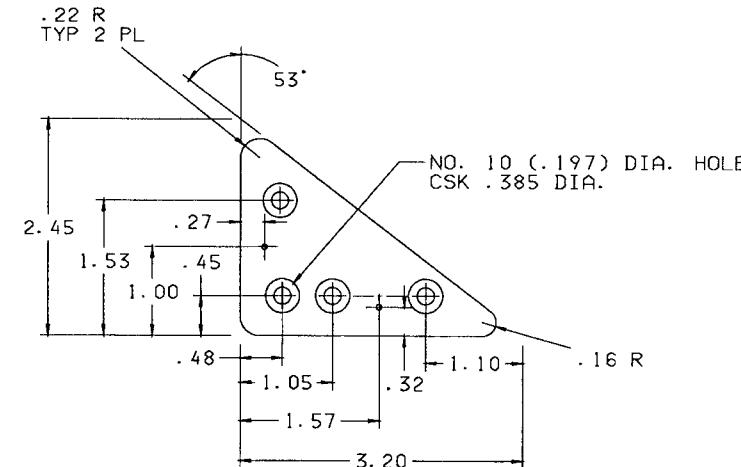
A



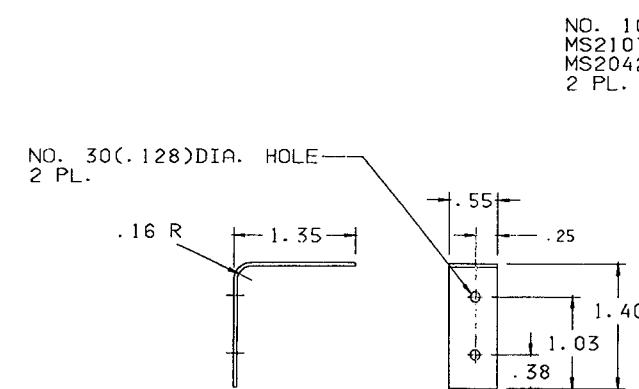
-23 MODIFICATION   
400SG125-2 (AIRCRAFT PART CORP.)



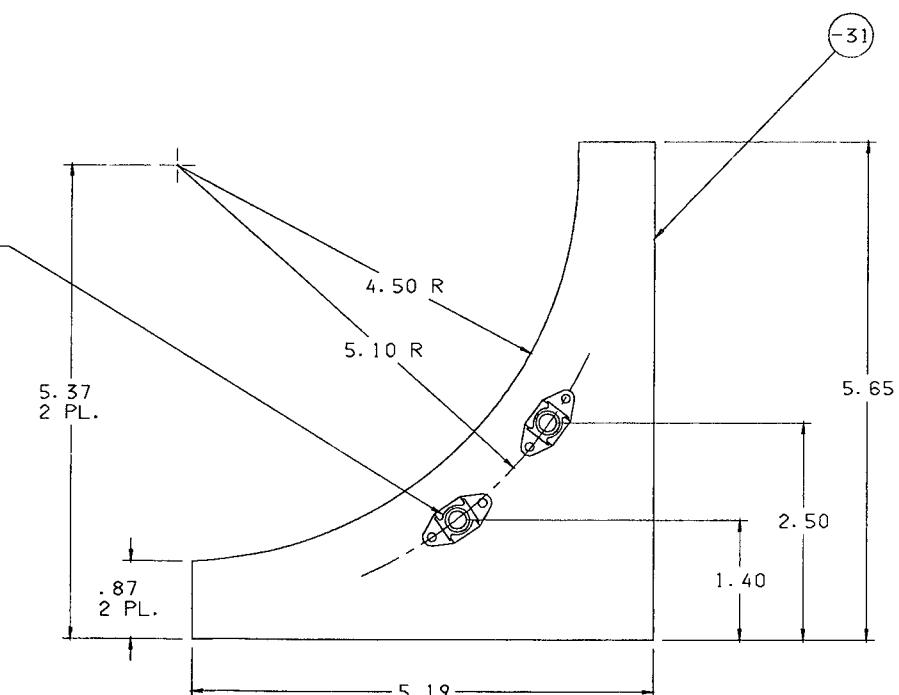
-43 BRACKET   
MAT'L.: .050 THK 2024-T3  
QQ-A-250/4



-41 SPLICE   
MATL: .090 THK ALUM 2024-T3  
QQ-A-250/4



-19 CLIP   
MAT'L.: .040 THK 2024-T3  
QQ-A-250/4



-37 ASSY   
MAT'L.: .050 THK 2024-T3  
QQ-A-250/4

SIZE CODE IDENT NO.  
D DSUV8 B23-13002  
REV G  
GEN/PUMP QUILL INSTALLATION SHEET 5 OF 5

8 7 6 5 4 3 2 1 STC'd PRINT B2313002, 05 ORIGINAL